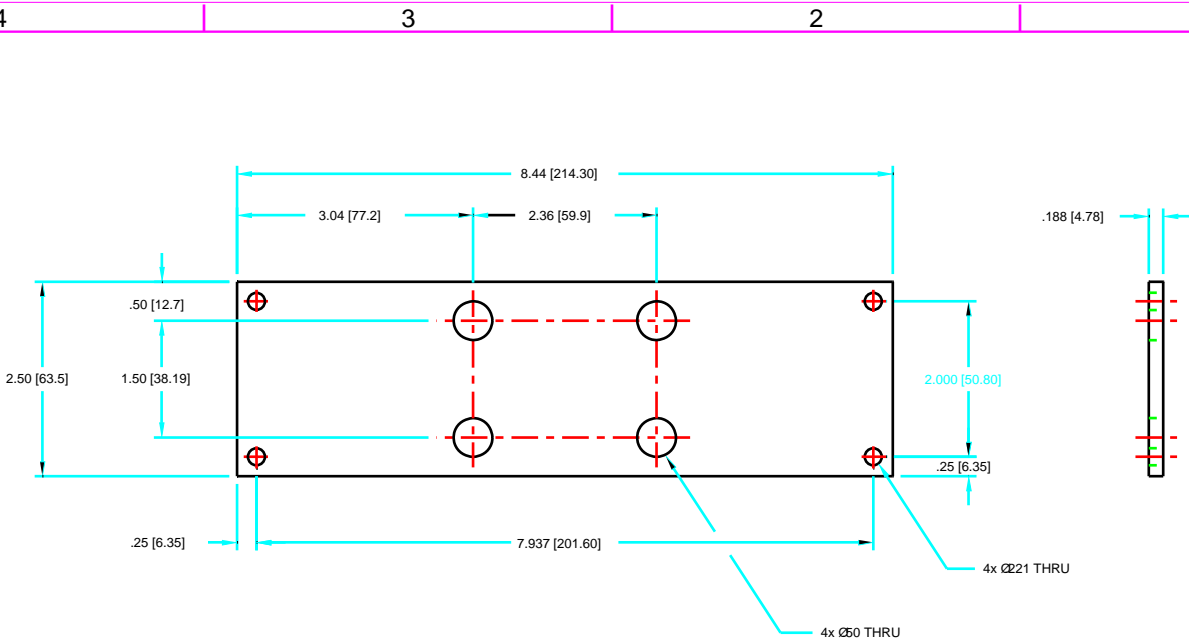



(C)	PLOT SCALE: 1=1	DWG. SCALE: 1	A1857301
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- NOTES:
1. THIS IS A ULTRA- HIGH VACUUM COMPONENT (UHV)
 2. WHEN MACHINING VACUUM PARTS, USE OF SILICONE AND SULPHUR-BASED CUTTING FLUIDS IS PROHIBITED. USE ONE OF THE FOLLOWING:
A) CIMCOOL 5 STAR 49
B) TRIM SOL
 2. THIS IS A UHV PART, ELECTROPOLISHING IS NEEDED BEFORE WELDING. PRIOR TO ELECTROPOLISHING, THE PART MUST GO THROUGH A MULTIPLE STEP CLEANING PROCESS INVOLVING DEGREASING, WASHING AND DRY NITROGEN BLOW DOWN.
 3. KEEP THE PART CLEAN AND WRAP FOR UHV PACKING WITH ALUMINUM FOIL.
 4. DIMENSIONS IN [] ARE MILLIMETERS AND FOR REF. ONLY
 5. SURFACE ROUGHNESS 63 ✓

1	NOTES UPDATED;	J.G.		
SYM	CHANGE DESCRIPTION	BY	CHKD	DATE
REVISIONS				

ITEM		DWG/PART NUMBER		NOMENCLATURE OR DESCRIPTION		MATERIAL / SPEC		QTY			
PARTS LIST											
<div>UNLESS OTHERWISE SPECIFIED: ALL DIMENSIONS ARE IN INCHES</div> <div>TOLERANCES</div> <div>DECIMALS ANGULAR</div> <div>X - .03 [.7620] - .25</div> <div>.XX - .01 [.254]</div> <div>.XXX - .005 [.127]</div> <div>SURFACE ROUGHNESS 63 ✓</div> <div>REMOVE ALL BURRS AND BREAK SHARP EDGES (3) MAX.</div> <div>SURFACE TEXTURE TO BE IN ACCORDANCE WITH LATEST ANSI B46.1</div> <div>DIMENSIONING & TOLERANCING IN ACCORDANCE WITH LATEST ANSI Y14.5</div> <div>DO NOT SCALE DRAWING</div>		LOG NUMBER		THIS DRAWING IS THE PROPERTY OF							
		A1857301				ARGONNE NATIONAL LABORATORY					
		DRAWN BY J.GOGOL		DATE 5/5/94		CHIEF DESIGN ENGINEER D.SHU		DATE 6/27/94		TITLE	
		J.CHANG		6/26/94		T.M.KUZAY		6/28/94		ADVANCED PHOTON SOURCE P5 I.D. W/M/S INTEGRAL SHUTTER BEAM STOP/COLLIMATOR RETAINING PLATE	
		DESIGNER J.GOGOL		DATE 5/5/94		PROJECT MGR.					
RESPONSIBLE ENGINEER J.CHANG		DATE 6/26/94		APPROVED/RELEASED							
MATERIAL		304 SST		SCALE 1:1		SIZE C		DRAWING NUMBER P4105090905-200001-01			
				SHEET 1 of 1							